

161851

Tuesday, May 23, 2017 10:58:03 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Stop *NS2*

20

Cust Item ID:

20

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

OC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

120	QC2- Inspect parts off machine FAI/FAIB	0.00	
120			DAS
QC			49
	Memo	0.20	<u>20</u> <u>8</u> <u>9-89</u>
Quality Control			17

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																									
Description Work Order Deviation				Disposition				Completed By _____ Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

Work Order ID 161851***161851***

Page 2

Tuesday, May 23, 2017 10:58:03 AM

Item ID: D3572-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Guide
Start Date: 6/9/2017 Start Qty: 20.00 ***20*** Cust Item ID:
Required Date: 6/20/2017 Req'd Qty: 20.00 ***20*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130						20	0		DAS 44 9-89 14-06-05
QC	Memo	0.40							
Quality Control									
140	Identify as per dwg & Stock Location: <u>wa002</u>	0.00							
140						20x			JUN 06 2017 DAS 26 9-89
Packaging	Memo	0.20							
Packaging	LOCATION: WA002								
150	QC21- Final Inspection - Work Order Release	0.00							
150									17/6/7
QC	Memo	2.00							
Quality Control									



JUN 06 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

Picklist Print

Tuesday, May 23, 2017 10:58:01 AM

Page 1

Work Order ID: 161851

161851

Parent Item: D3572-3

D3572-3

Parent Item Name: Guide

Start Date: 6/9/2017

Required Date: 6/20/2017

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B rev.B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased	No			100	f	28.1670	0.04	0.8004			

M6061T6B0 750X01 500

6061-T6 Bar .750 X 1.50

**

DAS
33
9-89

17/06/02

Location	Loc Qty	Loc Code
MAT	7.167	
m135247	0.557	
m135780	6.61	0.93'
MAT003	21	
m137043	1	
m137513	20	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



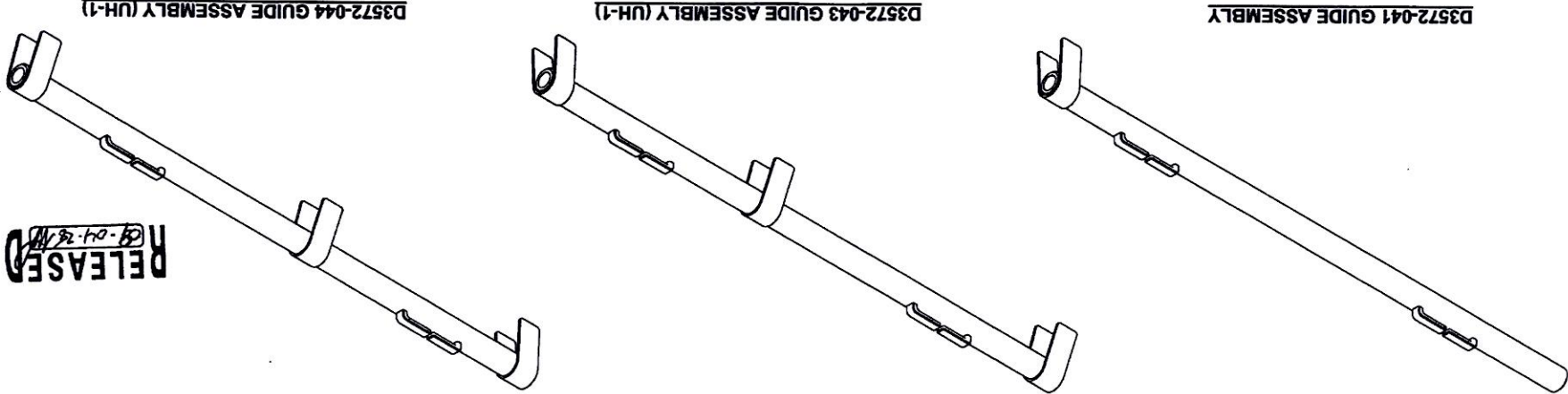
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1		D3572-1	TUBE
12	4	4		D3572-3	GUIDE
13	1	3		D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1615191
MAY 23 2017



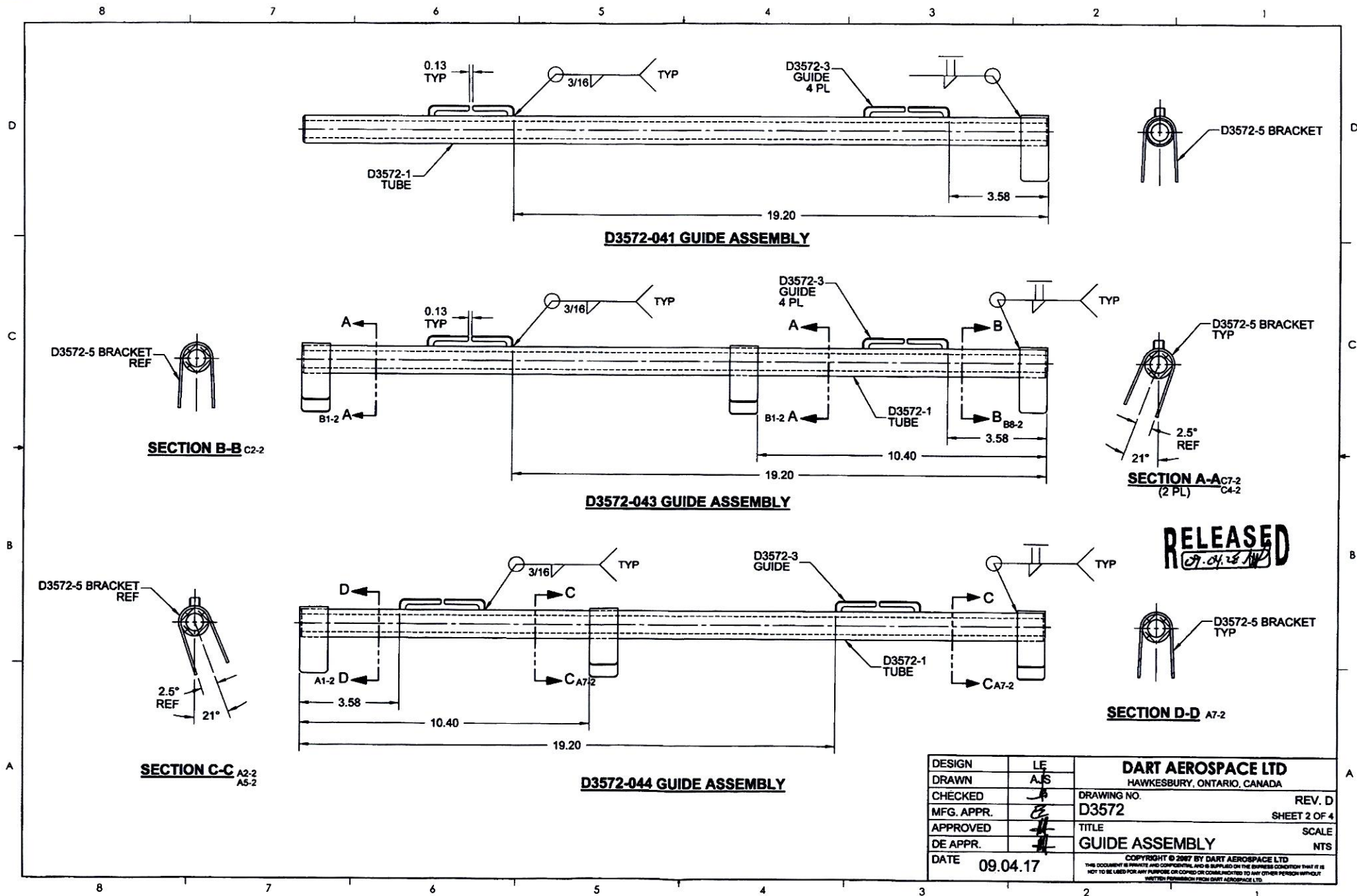
- NOTES:
- 1) MATERIAL: NONE
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
 - 8) WELDING: PER DART QSI 004

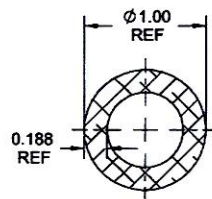
DATE	09.04.17
DESIGN	LE
DRAWN	AJS
CHECKED	AJS
MFG. APPR.	
APPROVED	
DE APPR.	
TITLE	GUIDE ASSEMBLY
DRAWING NO.	D3572
REV. D	
SCALE	SHEET 1 OF 4
NTS	
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REV.	DESCRIPTION	DATE
D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	09.04.17
C	REMOVE D3572-7	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILET	07.04.20
A	NEW ISSUE	07.03.29

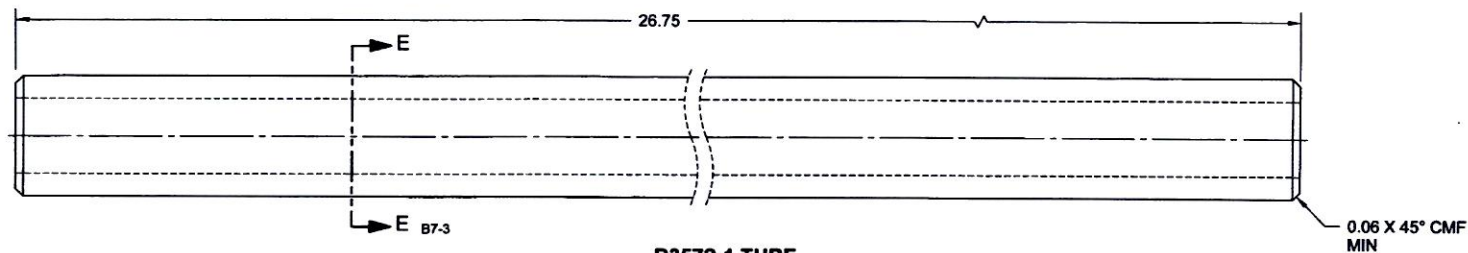
BY	DATE
LE	07.03.29
LE	07.04.20
AJS	09.04.17

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA





SECTION E-E CS-3



D3572-1 TUBE

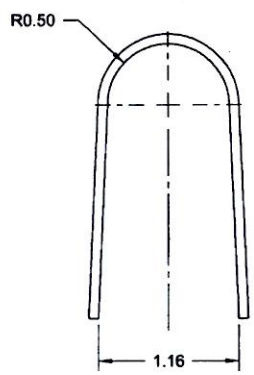
RELEASED
07/04/13 MP

D3572-1 NOTES:

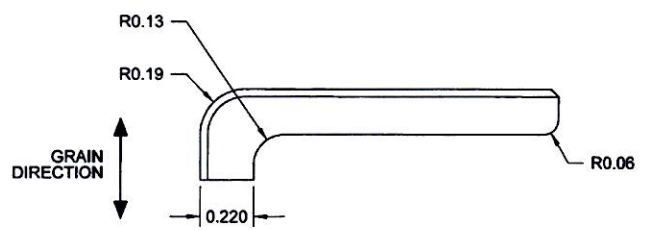
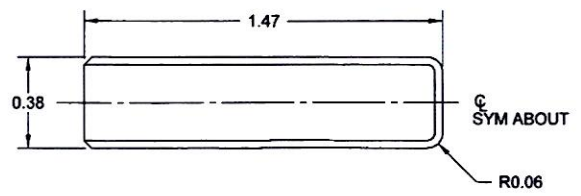
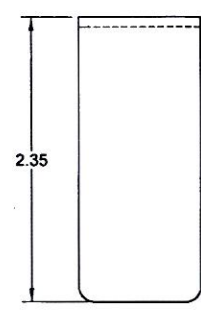
- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GUIDE ASSEMBLY	NTS
DATE	09.04.17	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

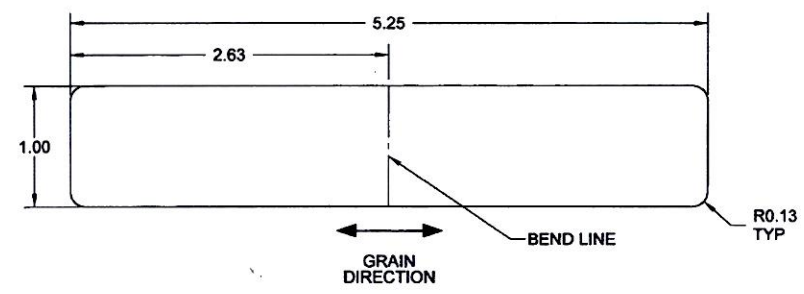
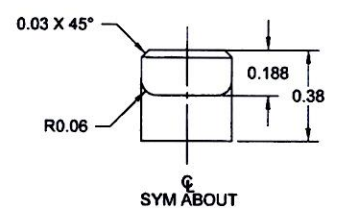
8 7 6 5 4 3 2 1



D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-3 GUIDE



D3572-5F FLAT PATTERN

RELEASED
9/04/17

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1